

Ship date Oct. 18

PRELIMINARY ISSUE

Work Order ID 62781

Friday, October 08, 2010 9:08:22 AM



Page 1

Item ID: D407-802-018

Accept



Setup Start



Revision ID: PRELIM

Item Name: Passenger Door Opener Installation, RH

Stop



Start Date: 10/8/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

10-08-10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN-D407-802-1

PA1

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D407-802-018 CHG001

[Signature]

105

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10/10/10

110

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

10-10-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62781

Friday, October 08, 2010 9:08:22 AM

Page 2

Item ID: D407-802-018

Accept

Revision ID: PRELIM

Item Name: Passenger Door Opener Installation, RH

Start Date: 10/8/2010 Start Qty: 1.00

Required Date: 10/15/2010 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD407-802-018 Location: _____ PPP rev: _____								
130	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

POSITIVE RECALL
EFFECTIVE 10-10-15 AUTH U
RELEASED _____ DATE _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Friday, October 08, 2010 9:08:26 AM

Work Order ID: 62781



Parent Item: D407-802-018



Parent Item Name: Passenger Door Opener Installation, RH

Start Date: 10/8/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.09.27 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3552-15 Door Prop		Manufactured	No				Each	2.0000	1	1			
-----------------------	--	--------------	----	--	--	--	------	--------	---	---	--	--	--

Location Loc Qty Loc Code

ST272A 2
62270 2

D3622-5 Ball Stud		Manufactured	No				Each	0.0000	1	1			
----------------------	--	--------------	----	--	--	--	------	--------	---	---	--	--	--

D4108-3 Door Doubler, Right		Manufactured	No				Each	0.0000	1	1			
--------------------------------	--	--------------	----	--	--	--	------	--------	---	---	--	--	--

D4108-5 Small Right Door Doubler		Manufactured	No				Each	0.0000	1	1			
-------------------------------------	--	--------------	----	--	--	--	------	--------	---	---	--	--	--

D4108-11 Template		Manufactured	No				Each	4.0000	1	1			
----------------------	--	--------------	----	--	--	--	------	--------	---	---	--	--	--

Location Loc Qty Loc Code

FG 4
62304 4

D4108-047 Sill Doubler Assembly		Manufactured	No				Each	0.0000	1	1			
------------------------------------	--	--------------	----	--	--	--	------	--------	---	---	--	--	--

63012 - 10/10/20

62286

62302

B 62303 10/10/13

62304

B 62305 - 10/10/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, October 08, 2010 9:08:26 AM

Page 2

Work Order ID: 62781

Parent Item: D407-802-018

Parent Item Name: Passenger Door Opener Installation, RH

Start Date: 10/8/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

CR3523-4-02

Purchased

No

Each

455.0000

19

19

RIVET

Location

Loc Qty

Loc Code

ST312

300

115768

300

ST313

155

113064

155

CR3523-4-4

Purchased

No

Each

100.0000

4

4

Rivet

Location

Loc Qty

Loc Code

ST314

100

115768

100

MS20426AD4-6

Purchased

No

Each

2,832.000

2

2

Rivet

Location

Loc Qty

Loc Code

ST317

2832

110139

2832

MS21073L5

Purchased

No

Each

89.0000

1

1

nut plate

Location

Loc Qty

Loc Code

ST303

89

113660

89

Friday, October 08, 2010 9:08:26 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, October 08, 2010 9:08:26 AM

Page 3

Work Order ID: 62781

Parent Item: D407-802-018

Parent Item Name: Passenger Door Opener Installation, RH

Start Date: 10/8/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

MS27039C1-27

Purchased

No

Each

50.0000

2

2

Screw

Location

Loc Qty

Loc Code

ST293

50

115768

50

NAS1149C0332R

Purchased

No

Each

4,993.000

2

2

Washer

Location

Loc Qty

Loc Code

ST297

4993

113524

10

113737

150

115000

125

115698

78

115816

1030

115832

3600

NAS1149C1165R

Purchased

No

Each

100.0000

2

2

Washer

Location

Loc Qty

Loc Code

ST297

100

115768

100

NAS1149C0532R

Purchased

No

Each

144.0000

6

6

WASHER

Location

Loc Qty

Loc Code

ST297

144

114348

44

115531

100

Friday, October 08, 2010 9:08:26 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, October 08, 2010 9:08:26 AM

Page 4

Work Order ID: 62781



Parent Item: D407-802-018



Parent Item Name: Passenger Door Opener Installation, RH

Start Date: 10/8/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0563R

Purchased

No

Each

200.0000

6

6



Washer



10/14/10

Location

Loc Qty

Loc Code

ST297

200

115768

200

115768

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

CHERRYMAX® RIVET SELECTION

INSTALLED WEIGHTS – Pounds per 1000 pieces (Ref.)

Rivet Diameter	Grip Length	Aluminum				Monel				INCO 600	
		Nominal		Oversize		Nominal		Oversize		Oversize	
		3212*	3213	3242	3243	3522*	3523	3552	3553	3852*	3853
		3214	3222*	3246*	3245	3524*		3556*	3555		
		3224*	3223	3252	3253						
		3224*			3255						
-4 (1/8")	-01*	.59	.69	.75	.88	—	1.28	1.10	1.32	—	1.35
	-02	.59	.79	.85	.99	1.05	1.52	1.14	1.58	1.16	1.61
	-03	.71	.93	.97	1.16	1.24	1.74	1.42	1.86	1.44	1.88
	-04	.86	1.07	1.14	1.33	1.44	1.90	1.70	2.14	1.72	2.17
	-05	1.00	1.21	1.31	1.50	1.66	2.16	1.98	2.42	2.01	2.44
	-06	1.14	1.36	1.47	1.66	1.88	2.38	2.26	2.70	2.28	2.73
	-07	1.28	1.50	1.64	1.83	2.00	2.61	2.54	2.98	2.56	3.02
	-08	1.42	1.64	1.81	2.00	2.22	2.83	2.82	3.26	2.89	3.29
	-09	1.56	1.78	1.98	2.17	2.44	3.05	3.10	3.54	3.22	3.66
-5 (5/32")	-01	—	1.26	—	1.55	—	2.41	—	2.46	—	2.53
	-02	1.02	1.41	1.34	1.71	1.84	2.81	1.87	2.90	1.99	2.98
	-03	1.22	1.63	1.56	1.98	2.15	3.14	2.26	3.34	2.37	3.44
	-04	1.45	1.86	1.82	2.24	2.50	3.46	2.87	3.78	2.90	3.91
	-05	1.67	2.08	2.09	2.51	2.86	3.81	3.30	4.22	3.33	4.26
	-06	1.90	2.31	2.36	2.78	3.22	4.17	3.74	4.66	3.85	4.77
	-07	2.12	2.53	2.63	3.05	3.58	4.53	4.18	5.10	4.31	5.21
	-08	2.35	2.75	2.90	3.32	3.94	4.92	4.62	5.54	4.75	5.67
	-09	2.57	2.98	3.16	3.58	4.29	5.24	5.06	5.98	5.19	6.13
	-10	2.79	3.20	3.43	3.85	4.64	5.56	5.50	6.42	5.63	6.55
	-11	3.01	3.42	3.70	4.12	4.99	5.87	5.94	6.86	6.07	6.97
-6 (3/16")	-01	—	2.01	—	2.39	—	3.84	—	3.99	—	4.13
	-02	1.75	2.20	2.00	2.58	3.04	4.38	3.12	4.51	3.24	4.65
	-03	2.00	2.52	2.28	2.93	3.54	4.87	3.69	5.08	3.82	5.22
	-04	2.33	2.85	2.62	3.27	4.04	5.38	4.27	5.66	4.33	5.80
	-05	2.64	3.16	2.97	3.62	4.54	5.86	4.85	6.24	4.97	6.37
	-06	2.97	3.49	3.32	3.97	5.04	6.36	5.43	6.82	5.55	6.95
	-07	3.28	3.80	3.67	4.32	5.54	6.86	6.01	7.40	6.13	7.53
	-08	3.61	4.13	4.02	4.67	6.04	7.36	6.59	7.98	6.72	8.11
	-09	3.93	4.45	4.36	5.01	6.54	7.86	7.17	8.56	7.30	8.69
	-10	4.25	4.77	4.71	5.36	7.04	8.35	7.75	9.14	7.88	9.27
	-11	4.57	5.09	5.06	5.71	7.54	8.85	8.33	9.72	8.47	9.85
	-12	4.90	5.42	5.41	6.06	8.04	9.34	8.91	10.30	9.05	10.44
-8 (1/4")	-02	—	4.79	—	—	—	9.17	—	9.92	—	10.28
	-03	4.08	5.35	4.50	5.74	6.98	10.01	7.45	10.95	7.73	11.37
	-04	4.61	5.92	5.32	6.57	7.63	10.80	8.58	11.98	8.90	12.42
	-05	5.14	6.49	5.71	7.14	8.98	12.29	9.71	13.01	10.07	13.41
	-06	5.67	7.06	6.28	7.81	10.04	13.28	10.84	14.04	11.24	14.54
	-07	6.20	7.63	6.91	8.48	11.05	14.20	11.97	15.07	12.38	15.67
	-08	6.73	8.19	7.54	9.11	12.38	15.26	13.10	16.10	13.62	16.70
	-09	7.26	8.76	8.17	9.74	13.01	16.25	14.23	17.13	14.80	17.73
	-10	7.79	9.33	8.80	10.37	13.64	17.23	15.36	18.16	15.96	18.76
	-11	8.32	9.90	9.43	11.00	15.81	18.21	16.49	19.19	17.09	19.79
	-12	8.85	10.47	10.06	11.63	16.78	19.18	17.62	20.22	18.24	20.82
	-13	9.36	11.03	10.69	12.26	17.73	20.13	18.75	21.25	19.36	21.86
	-14	9.91	11.60	11.32	12.89	18.69	21.09	19.88	22.28	20.51	22.89

*No 4-01 grip.

CR3523-X-X = CR3523-X-0X

10-11-02